

Date: Thursday, 3/2/2006 3:05:32 PM
 User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR
Job Number : 26015	
Estimate Number : 10877	
P.O. Number : N/A	Part Number : D205711013
This Issue : 3/2/2006 S.O. No. : N/A	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 25179	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/20/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.02</u>	
Comment : Est Rev: A 04.11.09 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D205-711-013 CHG001

DA : 06/03/06

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Issue for 709

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

U 0603-03

3.0	D412711041	Vertical Ref. Door Assy
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D412-711-041 Vertical Reference Door

25670

Attach serviceable tags

4.0	D205711113	Wiring Harness, 205
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D205-711-113 Wiring Harness, 205

B21902

Attach serviceable tags

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:05:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 26015

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

EA2046915205

Instrument Panel, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 EA20469-15-205 Instrument Panel, 205 M19150

Attach serviceable tags

Pu 3/13

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206/03/13

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-711-013

Location: _____

PPP Rev: _____

Pu 3/13

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 206/03/13 ①

Job Completion



U 06-03-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.Date: 03/07/2006 2:00:00 PM
User: Linda Lucette**Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
 Job Number : 25570
 Estimate Number : 10902 Part Number : D412711041
 P.O. Number : Drawing Number : N/A
 This Issue : 2/3/2006 S.O. No. : Project Number : N/A
 Print Rev. : NC Drawing Revision : N/A
 First Issue : 1/30/2006 Type : PURCHASED PARTS Material : N/A
 Previous Rev : 25569 Date Data : 2/28/2006 Qty: 1 Unit: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE DATE & USER
 Comment : Est Rev: A 04.06.18 New Issue KJDS

Additional Printout

Job Number:

Seq. #:

Machine Or Operation:

Description:

10

PG

PURCHASING

Comment: PURCHASING

Issue P/O:

495

to Eagle Copters

*Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

06102101

20

OUTSIDE SERVICE

OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 1/0 4236

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

U2046902 Sheet

1 Rev. 3

U2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 1/0 4236

1 EA20469-05 Rubber Strip 1/0 40359

1 EA20469-06 Aluminum Strip 1/0 40359

1 EA20469-07 Angle 1/0 40359

1 EA20469-08 Placard N/A

1 EA20469-10 Rear Fib Assy 1/0 40359

1 EA20469-11 Angle 1/0 40359

Date: Friday, 2/3/2008 2:20:10 PM
User: Linda Loeble

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26670

Part Number: D412711041

Job Number:

- 1 EA20469-12 Fwd Rib W/P 40357
1 EA20469-13 Window W/P 40357
1 EA20469-14 Window Retainer W/P 40357
1 EA20469-16 Armrest Assy W/P 40357
1 EA20469-17 Angle W/P 40357
1 EA20469-18 Door Inner Skin W/P 40357
1 EA20469-21 Door Cover Panel W/P 40357
2 EA20469-23 Link W/P 40309
1 EA20469-24 Rod W/P 42376
1 EA20469-25 Arm Assy W/P 40357
- Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

- | Qty | Part Number | Description | Batch |
|-----|----------------------|-------------|---------------------|
| 14 | AN3-3ABolt | | <u>LT-05-022408</u> |
| 22 | AN3-4ABolt | | <u>LT-05-022408</u> |
| 24 | AN3-7ABolt | | <u>LT-05-022408</u> |
| 6 | AN380-0L Washer | | <u>LT-01-3057</u> |
| 60 | AN980-10L Washer | | <u>LT-01-3057</u> |
| 34 | CR3242-4-2 Rivet | | <u>LT-05-022444</u> |
| 135 | MS20426AD3-3 Rivet | | <u>LT-05-022460</u> |
| 140 | MS20426AD4-3 Rivet | | <u>LT-05-022460</u> |
| 26 | MS20470AD3-3 Rivet | | <u>LT-05-022472</u> |
| 90 | MS20470AD4-3 Rivet | | <u>LT-05-022440</u> |
| 24 | MS21042L3 Nut | | <u>LT-05-022444</u> |
| 2 | MS21042L08 Nut | | <u>LT-05-022474</u> |
| 13 | MS21069L3 Nut Plate | | <u>LT-05-022408</u> |
| 8 | MS21069L08 Nut Plate | | <u>LT-05-022430</u> |
| 1 | MS21071L3 Nut Plate | | <u>LT-05-022440</u> |
| 1 | MS21071L08 Nut Plate | | <u>LT-05-022479</u> |
| 6 | MS21075L3 Nut Plate | | <u>LT-05-022470</u> |
| 2 | MS24877-12 Screw | | <u>LT-05-011731</u> |
| 6 | MS27039-1-09 Screw | | <u>LT-05-016746</u> |

4-Assemble door in accordance with: D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Form: rprocess4

03/07/2006 14:52 FAX

004/004

02/02/2006 16:03 '6136321053'

DART AEROS-

PAGE: 07

Del: Friday, 2/3/2006 2:30:10 PM
User: Linda Lapelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25670

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



J. Ressler



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS
Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DL 06/03/08 ⑦

Job Completion



W 06.03.08

DART

1270 Aberdeen Street
Hawkesbury, Ontario Canada K6A 1K7
www.dartaero.com

FAX COVER SHEET

To: LINDA

From: JASON

Tel:

Cell:

Fax:

REMARKS:

- ☐ Urgent
- ☐ For your review
- ☐ Reply ASAP
- ☐ Please Comment

IPP FOR AIBU DULAI DOOR.

B 25670

JASON



"Providing our customers with aerospace products and services which meet their expectations and contract requirements"

Date: Monday, 1/30/2006 3:43:55 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL REFERENCE DOOR ASSEMBLY	
Job Number :	25670			
Estimate Number :	10902			
P.O. Number :		Part Number :	D412711041	
This Issue :	1/30/2006	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	N/A	
First Issue :	1/1	Project Number :	N/A	
Previous Run :	25669	Drawing Revision :	N/A	
		Material :	N/A	
Written By :		Due Date :	2/28/2006	Qty: 1 Um: Each
Checked & Approved By :	<i>KA 06.01.30</i>			
Comment :	Est Rev:A 04.08.18 New Issue KJ/DS			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: *495* to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES

**Comment:** Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door _____

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window _____

1 EA20469-05 Rubber Strip _____

1 EA20469-06 Aluminum Strip _____

1 EA20469-07 Angle _____

1 EA20469-08 Placard _____

1 EA20469-10 Rear Rib Assy _____

1 EA20469-11 Angle _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25670

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	EA20469-12	Fwd Rib
1	EA20469-13	Window
1	EA20469-14	Window Retainer
1	EA20469-16	Armrest Assy
1	EA20469-17	Angle
1	EA20469-18	Door Inner Skin
1	EA20469-21	Door Cover Panel
2	EA20469-23	Link
1	EA20469-24	Rod
1	EA20469-25	Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
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14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L Washer		
90	AN960-10L Washer		
34	CR3242-4-2 Rivet		
135	MS20426AD3-3 Rivet		
140	MS20426AD4-3 Rivet		
25	MS20470AD3-3 Rivet		
90	MS20470AD4-3 Rivet		
24	MS21042L3 Nut		
2	MS21042L06 Nut		
13	MS21069L3 Nut Plate		
8	MS21069L08 Nut Plate		
1	MS21071L3 Nut Plate		
1	MS21071L08 Nut Plate		
9	MS21075L3 Nut Plate		
2	MS24677-12 Screw		
6	MS27039-1-09 Screw		

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25670

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries